

DART
AEROSPACEDart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
CanadaTel (613) 632-5200
Fax 613 632-5246**RBA9829****Job Sheet 200884****Part No:** RBA9829**Job Qty:** 2 pcs *5 MLL***Part Name:** Main Rotor Mast Nut Wrench (MD Design)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 9/18/19**Job Tracking No:****Due Date:** 11/14/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:** ORDER 19501**Note:** DWG RBA9829 Rev 3 IPP Rev. A 19.09.18 New issue DP Verify DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	11/14/19		0.25	0.50	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	2 pcs	11/14/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
120	QC 8	2 pcs	11/14/19		0.00	0.00			

*GP 19-11-21**DAS 40 NOV 22 2019 9:59*

Plex 9/18/19 1:13 PM Dart.lajeunesse

				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
130	Packaging 3-1 - Stock - B4B 2 pcs	11/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG 2 pcs	11/14/19	0.00 0.00	QC 21 - FG - 21	DAS 21 3-00
					NOV 27 2019

QC 21 - FG - 70

QC 21 - SA - 53

Part Op 100 - Small Fab-9 (Small Fab) Assemble

Descriptions: 110 - QC5 (QC5- Inspect part completeness to step on W/O)

120 - (QC8- Inspect parts - second check

130 - Packaging3-2 (Identify as per dwg & Stock Location:) Identify and Stock

140 - QC21 (QC21- Final Inspection - Work Order Release)

GA140 B

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN315-4	Nut ST331	10 4 pcs (2 ea)	100-Small Fab - 1	03656
AN4-10A	Bolt ST345	10 4 Ea (2 ea)	100-Small Fab - 1	5233815
MS20470AD-4-6	Rivet Ø1/8 X 3/8 ST310	40 16 (8 ea)	100-Small Fab - 1	144562
RBA9829-3	Wrench 140B	5 2 pcs (1 ea)	100-Small Fab - 1	178038
RBA9829-5	Swivel Plate 140B	5 2 pcs (1 ea)	100-Small Fab - 1	230265 223696
RBA9829-7	Retaining Plate 140B	5 2 pcs (1 ea)	100-Small Fab - 1	221866
				224945
NAS1149F0463P GA202.				201001

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	AN315-4	4	18	0
	AN4-10A	4	70	0
	MS20470AD-4-6	16	0	0
	RBA9829-3	2	0	0
	RBA9829-5	2	0	0
	RBA9829-7	2	0	0

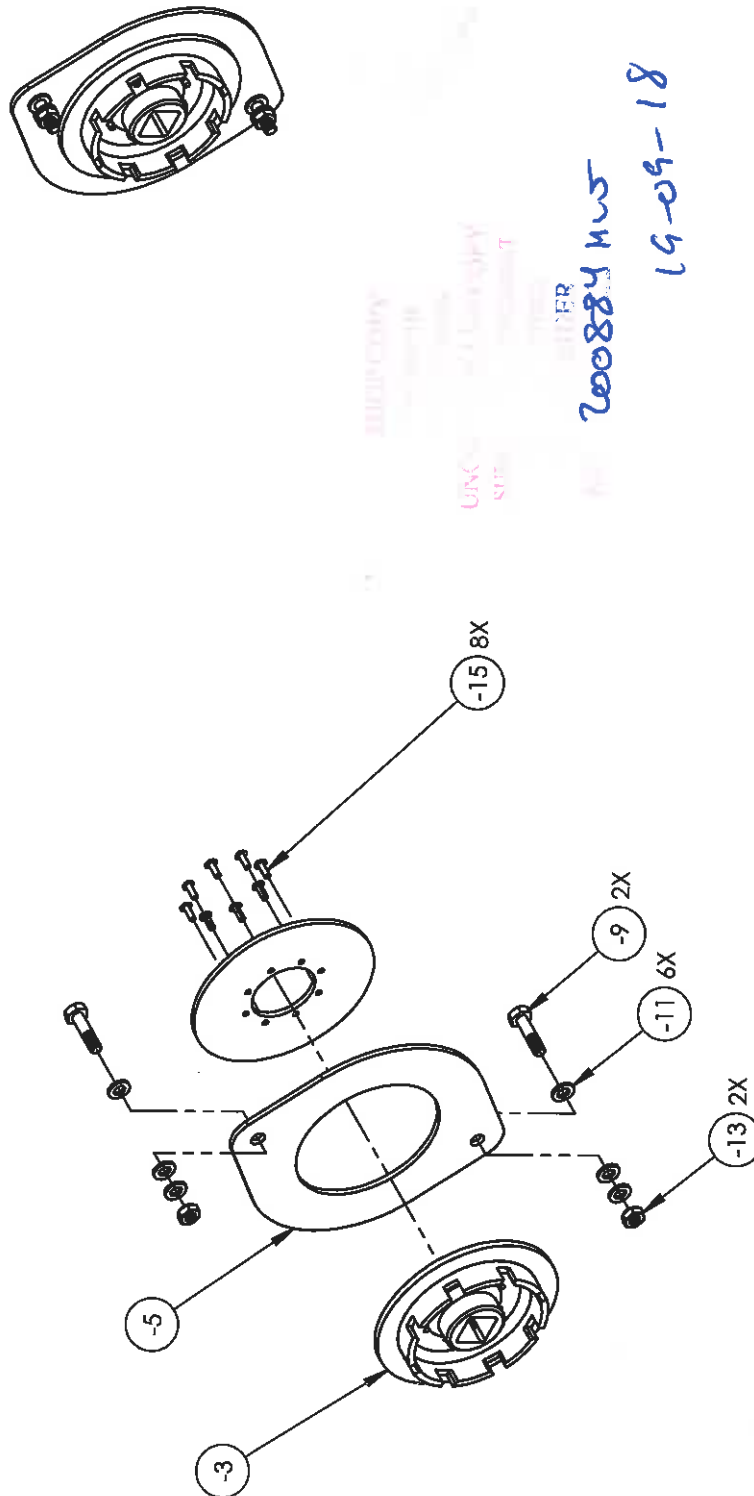
Part Specifications

Specifications could not be found.

Plex 9/18/19 1:13 PM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CHD TITLEBLOCK & REVISION BLOCK. ADDED ASSY, DWG., ADDED FINISH SPEC P/N -3, -5, -7, ADDED ENGRAVE NOTE, ADDED HEAT TREAT P/N -3, CHD TOOL NUMBER FROM 369A9829.	10/28/2009	RJC	RW
B		ADDED -3 MISSING DIMENSION PER G.E.	11/11/2011	RJC	RW
3	15-0332	UPDATED TO NEW DRAFTING STANDARDS. ADDED DASH NUMBERS FOR HARDWARE. -3 CHD DIMS WAS BX Ø1.285 IS BX Ø1.285-1.335. WAS 750 SQ IS 2X 753-758. WAS 875 IS (875) ADDED DIMS 2X 1.005 MIN. Ø3.312. -5 ADDED "SWIVEL" TO DESCRIPTION ON DWG. -7 ADDED "RETAINING" TO DESCRIPTION ON DWG. CHD DIM BX Ø1.285 IS BX Ø1.285-1.335. -15 CHD B/O REF WAS #M520470-4-6 IS #M520470AD-4-6. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS.	10/13/2015	DPD	JAG



200884 HW5 81-50-51



ROTOR MAST NUT WRENCH

QTY		Part #	Description	Material	3/O INFORMATION OR SPECIFICATIONS		PG.	DWG NO.	RBA9829		REV
		-3	1	WRENCH	41140		2				3
		-5	1	SWIVEL PLATE	6061		3			DRAWN BY: COLE	
		-7	1	RETAINING PLATE	6061		4			APPROVED	
		8/O	2	BOLT	STEEL	1/4-28 X 1.031 (AN4-10A)	1			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
		8/O	6	WASHER	STEEL	Ø1/4 (AN960-416)	1			XXX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1	
		8/O	2	NUT	STEEL	1/4-28 (AN315-4)	1			1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
		8/O	8	RIVET	ALUMINUM	Ø1/8 X 3/8 (MS20470AD-4-6)	1			2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
										USED ON MODEL	
										MD-500	

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

1

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J